

Work Order ID 55337

January 13, 2010 10:26:24 AM

Page 1

Item ID: D3209-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 1/13/10 Start Qty: 4.00

Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

10-1-13

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3209

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

and 10/01/16

4

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3209-1 as per Folio FA345 and Dwg D32091 Identify as D3209-1

Deburr and Tumble

and 10/01/17

4

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

and 10/01/17

4

0

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

B.A 01/10/18

4

Ø

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

BK 10-01-18

TH

Ø

HandFinish

Memo

0.00

Hand Finishing

Press Bushing = 7 mm-1 10/02/02 (4X)

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

Powdercoat

Memo

0.00

⇒ 21 10-01-19 x 4 Ø

Powder Coating

Note: Cover the hole for D3209-1 before powder coat. START
TIME: 2:45 PM OVEN TEMPERATURE:
3:15 PM FINISH TIME: 3:20 PM

W/O: 55337		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	161	Press fit bushing as per Dwg permanent chg	BE	10.01.17			

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Start Date: 1/13/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 10-01-19 (4) P

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10.02.02 Press fit bushing D3209-3 m-h 10/02/02

2/8.10/02/02

(4X)

10-1-19

(4)

Pho →
Previous page

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

1/14/13

4

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Cust Item ID:

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Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03 *[Signature]*
MR
10-2-3

W/O:		WORK ORDER CHANGES					
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Picklist Print

January 13, 2010 10:26:29 AM

Page 1

Work Order ID: 55337



Parent Item: D3209-041



Parent Item Name: Bracket Assembly

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP A1104.06.09 New issue KJ/RF

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3209-3		Manufactured	No			100	Each	59.0000	4.0000			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Bushing

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

59

35633

18

40930

41

M6061T6B1.500X01.25
0

Purchased No

170

f

66.3728

0.7368



6061-T6 Bar 1.50 x 1.25

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

MAT

66.3728

107461

11.84

110936

54.5328

7368

10/01/16

M. L
10/02/02

4X

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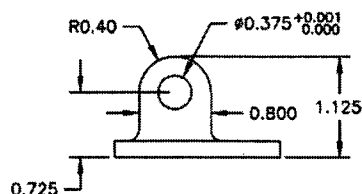
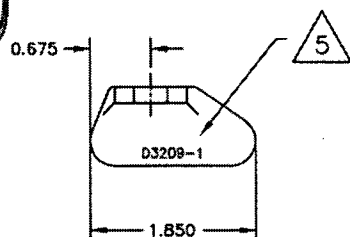
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DART

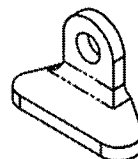
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 [Signature]

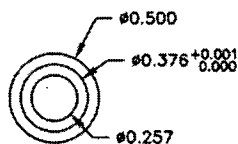
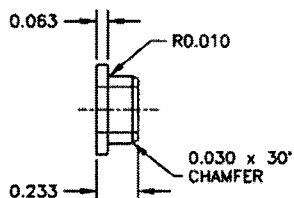
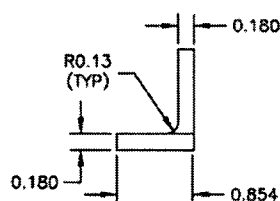


2

D3209-1 BRACKET



SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55337
10-1-13



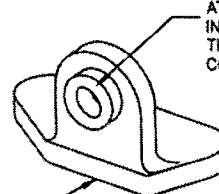
3

D3209-3 BUSHING
SCALE 1:2

4

D3209-041 ASSEMBLY

D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT



D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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